

**Work Order ID 55103**

January 6, 2010 9:46:57 AM

Page 1

Item ID: D3589-049

Accept



Setup

Start



Revision ID:

Item Name: Aft Guide

Stop



Start Date: 06/01/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-1-13

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3589	Rev B

100 Weld per dwg A/R S.S. rod Batch: M109213 0.00



Large Fab

Memo 0.00

Large Fab

1- assemble and weld as per dwg D3589 QS1004

A/R Stainless Steel rod batch: M109213

  
10.01.13

110

QC9- Inspect visual per QS1004- Fusion Welds 0.00



QC

Memo 0.00

Quality Control

  
PL 10/01/13

120

QC5- Inspect part completeness to step on W/O 0.00



QC

Memo 0.00

Quality Control

  
S. idelis

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 55103**

January 6, 2010 9:46:58 AM

Page 2

Item ID: D3589-049

Accept



Setup Start



Revision ID:

Item Name: Aft Guide

Stop



Start Date: 06/01/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 15/01/2010 Req Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/  
Work Center ID**
**Operation  
Description**
Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: 72

0.00

10-1-18

SO



Packaging

Memo

0.00

Packaging

140



QC21- Final Inspection - Work Order Release

0.00

10/01/19

QC

Memo

0.00

Quality Control

MF 10-1-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Picklist Print**

Page 1

January 6, 2010 9:47:02 AM

Work Order ID: 55103



Parent Item: D3589-049



Parent Item Name: Aft Guide

Start Date: 06/01/2010

Required Date: 15/01/2010

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replaced Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3589-19		Manufactured	No			100	Each	4.0000	2.0000			

Aft Guide Plate

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

4

46193

4

PD 10.01.13

D3589-5

Manufactured No

100 Each 4.0000 2.0000

LATCH GUIDE

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

4

46104

4

PD 10.01.13

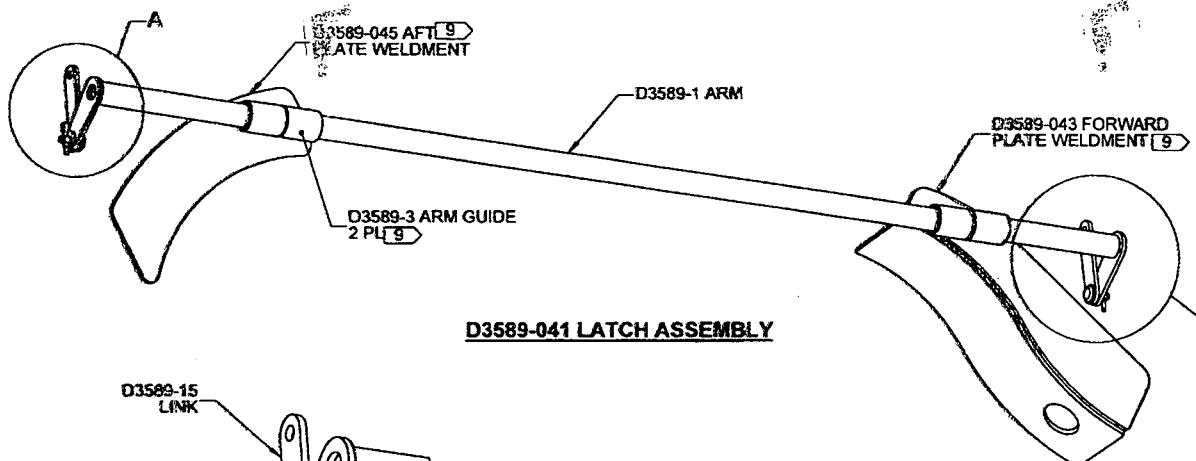
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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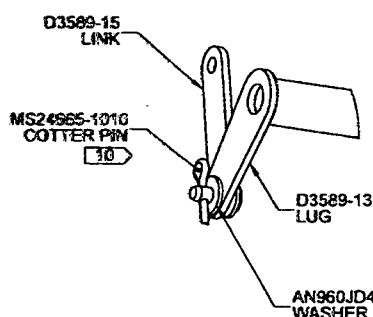
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY	PN	DESCRIPTION
1	D3583-041	LATCH ASSEMBLY
1	D3583-045	AFT PLATE WELDMENT
1	D3583-043	FORWARD PLATE WELDMENT
1	D3583-1	ARM
2	D3583-3	ARM GUIDE
2	D3583-13	LUG
2	D3583-15	LINK
4	AN960JD4	WASHER
2	MS20332-1C7	PIN
2	MS24565-1010	COTTER PIN



D3589-041 LATCH ASSEMBLY

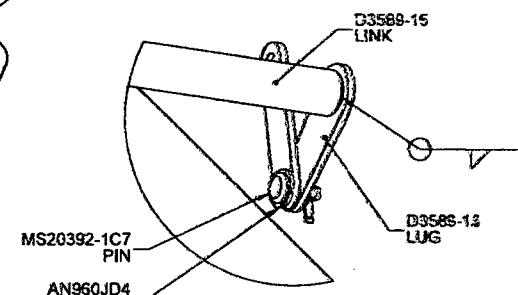


#### **DETAIL A: LINK ASSEMBLY DETAIL**

SCALE 2X  
2 P

- D3589-041 NOTES:**

  - 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-041" USING P
  - 7) WEIGHT: 0.73 lbs
  - 8) WELDING: PER DART QSI 004 USING DT9033
  - 9) IDENTIFIED PARTS ARE LOOSE ON D3589-1 ARM
  - 10) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540



**DETAIL B: WELDING AND  
LINK ASSEMBLY DETAIL**

SCALE 1  
7 P

RELEASED

B	0.50 AND 0.53 REF. WERE 1.37 AND 0.50 (ZN C5-2); 0.50 WAS 1.09 (ZN C5-2); 0.75 REF REPLACES 2.01 (ZN C4-3); 23° WAS 15° (ZN B2-2); 19.00 WAS 13.00 (ZN D4-4). REDESIGNED D3589-9 (ZN A5-6) AND D3589-11F (ZN C2-3) REASON: REDESIGN FOR PROPER FIT AND TO MATCH TESTED CONFIGURATION		M3	08.06.25
A	NEW ISSUE		M3	08.05.29
REV.		DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAMMERSLEY, ONTARIO, CANADA		
DRAWN		DRAWING NO.	REV. B	
CHECKED		D3589	SHEET 1 OF 8	
MFG. APPR.		TITLE	SCALE	
APPROVED		LATCH ASSEMBLY	NTS	
DE APPR.				
DATE	08.06.25	COPYRIGHT © 2004 BY SMART FACED SERVICE LTD THE DOCUMENT IS PROVIDED FOR INFORMATIONAL PURPOSES ONLY. IT IS NOT TO BE CONSTRUED AS AN OFFICIAL CONTRACT. ANY USE OF THE INFORMATION CONTAINED IN THIS DOCUMENT IS AT THE RISK OF THE PERSON WHO RECEIVED IT. NO WARRANTY IS PROVIDED OR IMPLIED.		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

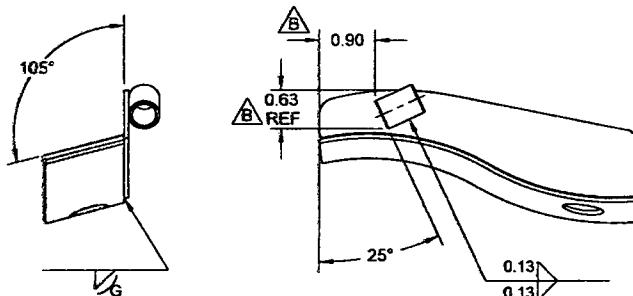
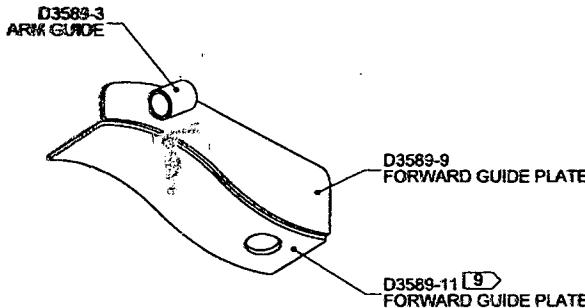
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

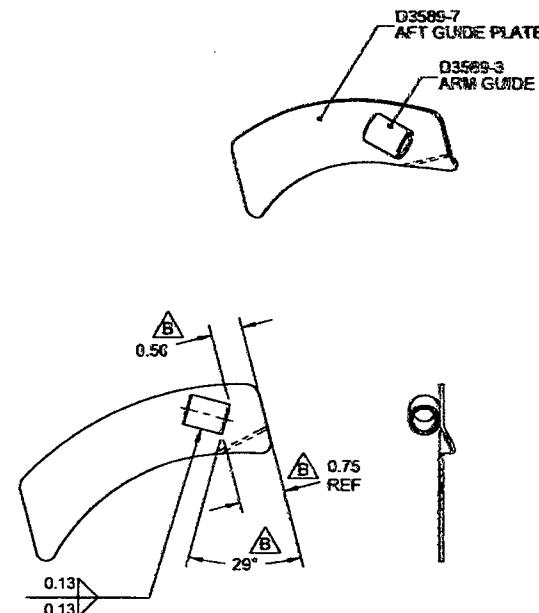
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -043	QTY -045	P/N	DESCRIPTION
X		D3589-043	FORWARD PLATE WELDMENT
	X	D3589-045	AFT PLATE WELDMENT
1	1	D3589-3	ARM GUIDE
1	1	D3589-7	AFT GUIDE PLATE
1		D3589-9	FORWARD GUIDE PLATE
1		D3589-11	FORWARD GUIDE PLATE



**D3589-043 FORWARD PLATE WELDMENT**



**D3589-045 AFT PLATE WELDMENT**

D3589-043/-045 NOTES:

- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: .005 TO .010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT:
    - D3589-043 = 0.22 lbs
    - D3589-045 = 0.10 lbs
  - 8) WELDING: PER DART QSI 004 USING DTS033
  - 9) FORM D3589-11 TO FIT D3589-9 MATING EDGE

DESIGN	<u>A</u>	DART AEROSPACE LTD	
DRAWN	<u>B</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>B</u>	DRAWING NO.	REV. B
MFG. APPR.	<u>B</u>	D3589	SHEET 2 OF 6
APPROVED	<u>AB</u>	TITLE	SCALE
DE APPR.	<u>AB</u>	LATCH ASSEMBLY	
DATE	08.06.25	COPYRIGHT © 2008 DART AEROSPACE LTD THE DOCUMENTS CONTAINED HEREIN ARE PROPRIETARY AND IS UPLOADED ON THE EXPRESS CONDITION THAT IT NOT BE USED FOR ANY PURPOSE OTHER THAN CONFIDENTIAL TO ANY OTHER PERSON WITHOUT	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

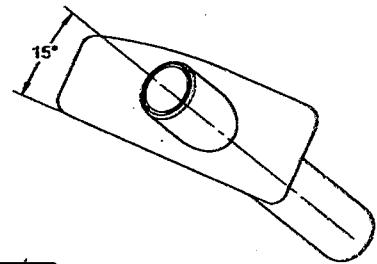
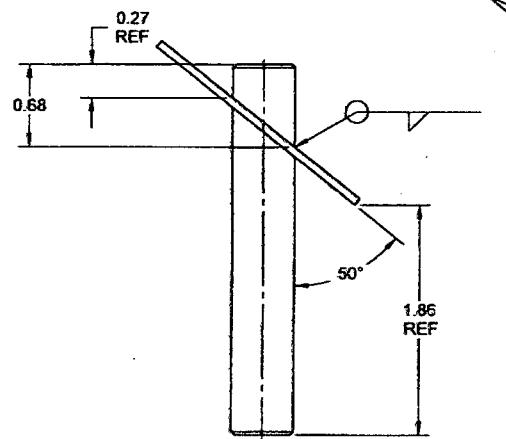
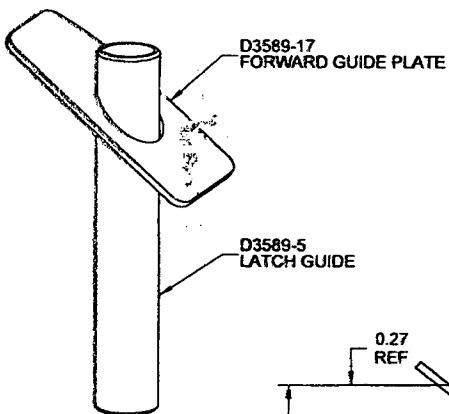
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

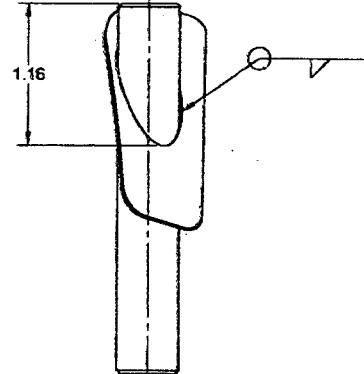
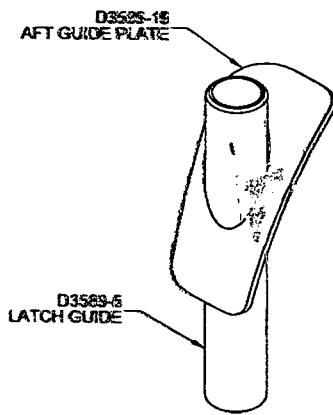
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

QTY -047	QTY -049	P/N	DESCRIPTION
X	X	D3589-047	FORWARD GUIDE
	X	D3589-049	AFT GUIDE
1	1	D3589-5	LATCH GUIDE
1		D3589-17	FORWARD GUIDE PLATE
1		D3589-19	AFT GUIDE PLATE



D3589-047 FORWARD GUIDE



D3589-049 AFT GUIDE

RELEASED  
06/06/10  
w/o 55103

DESIGN	<i>4</i>	DART AEROSPACE LTD	
DRAWN	<i>6</i>	HALIFAX, ONTARIO, CANADA	
CHECKED	<i>6</i>	DRAWING NO. REV. B	
MFG. APPR.	<i>6</i>	D3589 SHEET 3 OF 8	
APPROVED	<i>40</i>	TITLE SCALE	
DE APPR.	<i>40</i>	LATCH ASSEMBLY INTS	
DATE	08.06.25	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. NOT TO BE COPIED OR REPRODUCED, COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

D3589-047/049 NOTES:  
 1) MATERIAL: INKA  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER  
 7) WEIGHT: 0.07 lbs EACH  
 8) WELDING: PER DART QSI 004

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

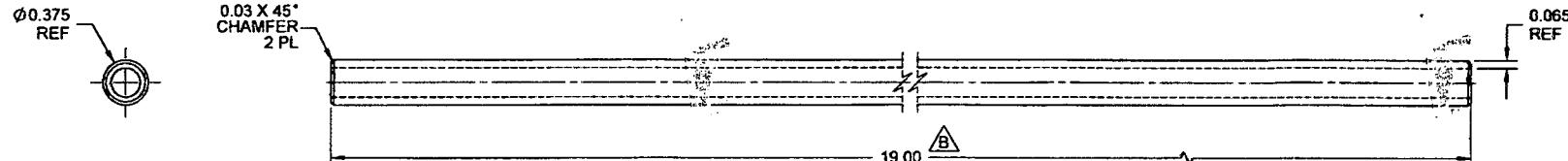
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3

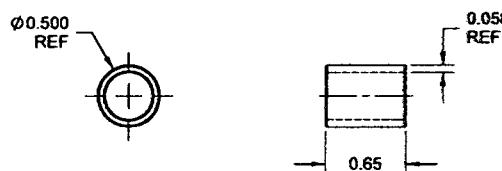
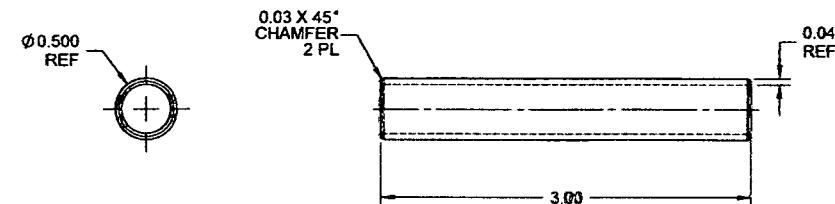
2

1

D

D3589-1 ARM

C

D3589-3 ARM GUIDED3589-5 LATCH GUIDE

B

*RELEASED  
01/05/04*

*w/o 55103*

DESIGN	<i>1</i>	DART AEROSPACE LTD
DRAWN	<i>A</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PH</i>	DRAWING NO. REV. B
MFG. APPR.	<i>NA</i>	D3589 SHEET 4 OF 8
APPROVED	<i>AD</i>	TITLE SCALE
DE APPR.	<i>AT</i>	LATCH ASSEMBLY NTS
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8

7

6

5

4

3

2

1

A

## D3589-1/3/5 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING  
 D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)  
 D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)  
 D3589-5: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: - D3589-1 = 0.34 lbs  
 - D3589-3 = 0.01 lbs  
 - D3589-5 = 0.06 lbs

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

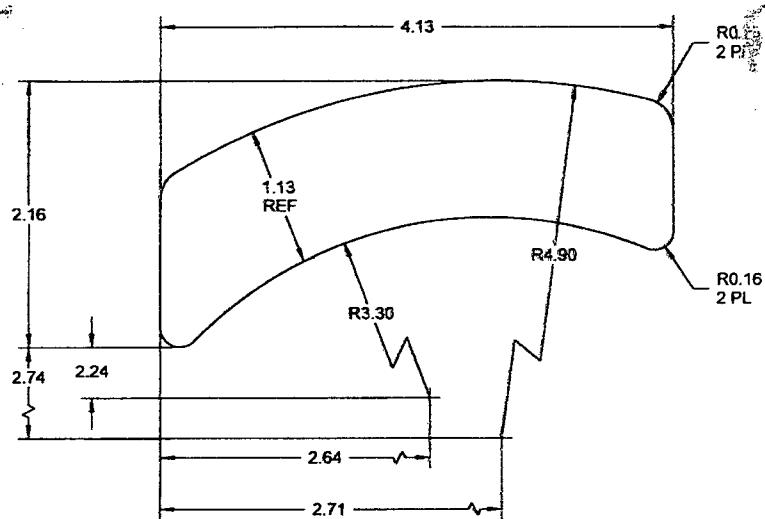
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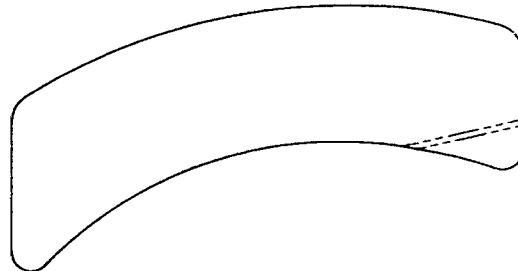
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

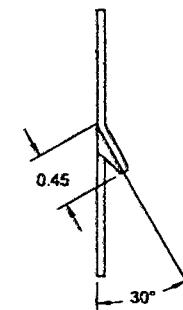
8 1 7 1 6 1 5 1 4 1 3 1 2 1 1



D3589-7F AFT GUIDE PLATE  
FLAT PATTERN



D3589-7 AFT GUIDE PLATE  
MAKE FROM D3589-7F



- D3589-7/-7F NOTES:  
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524,  
 OR MIL-S-5059 (ANNEALED) 2B FINISH  
 16 GAUGE (0.063 THICK). (REF. DART SPEC M304S16GA)  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: .005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.09 lbs

DESIGN	<i>M</i>	DART AEROSPACE LTD
DRAWN	<i>AS</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AS</i>	REV. B
MFG. APPR.	<i>AS</i>	DRAWING NO.
APPROVED	<i>AS</i>	SHEET 5 OF 6
DE APPR.	<i>AS</i>	TITLE
DATE	08.06.25	SCALE
		NTS

*w/10 55103*

RELEASED  
*07/05/11*

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8 1 7 1 6 1 5 1 4 1 3 1 2 1 1

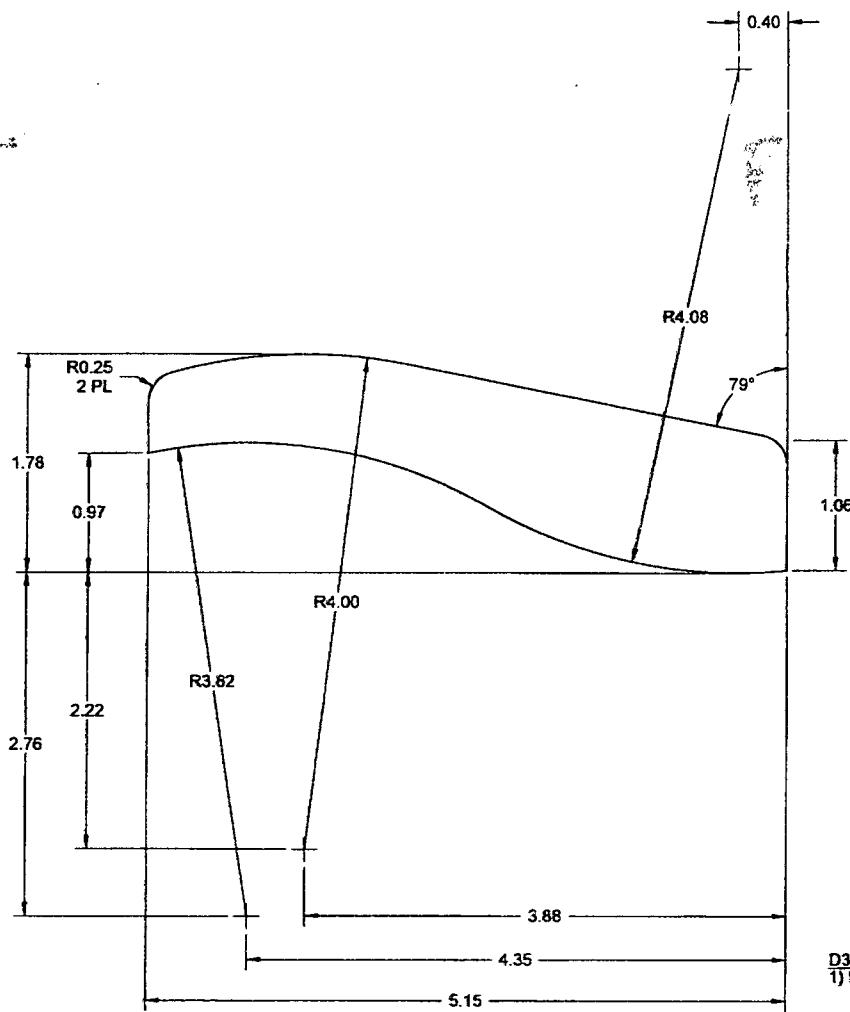
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

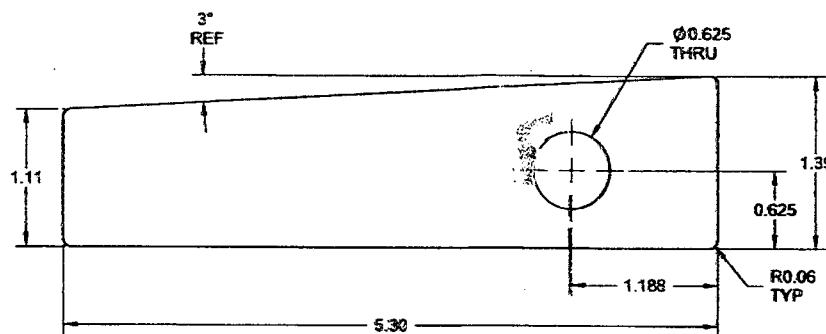
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

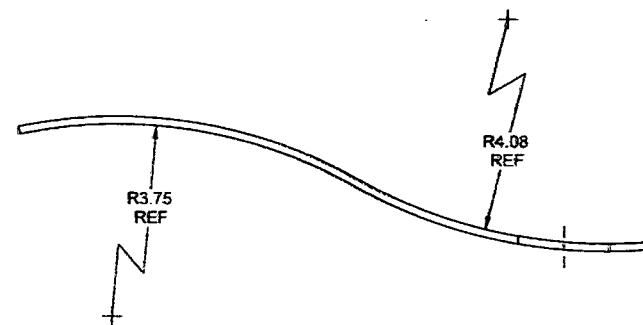
NOTE: Date & initial all entries



D3589-9 FORWARD GUIDE PLATE A



D3589-11F FORWARD GUIDE PLATE  
FLAT PATTERN A



D3589-11 FORWARD GUIDE PLATE  
(MAKE FROM D3589-11F)

RELEASED  
S/22/05/10

w/o 55103

D3589-9-11-11F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs EACH
- 8) CONTROL SHAPE PER DT9021 TEMPLATE

DESIGN	A	DART AEROSPACE LTD
DRAWN	A	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO.
MFG. APPR.	N	REV. B
APPROVED	MP	D3589
DE APPR.	H	SHEET 6 OF 6
DATE	08.06.25	TITLE
		SCALE
		NTS
FORWARD GUIDE PLATE		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

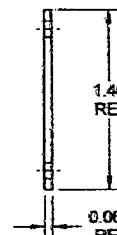
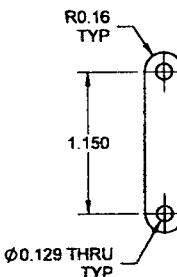
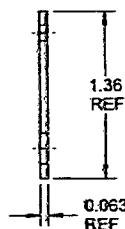
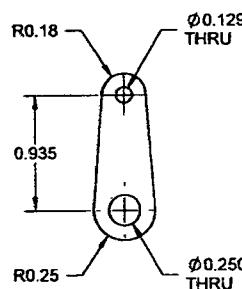
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1 1



D3589-15 LINK

RELEASED  
07/02/05 AM

W/0 05163

## D3589-13/-15 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524,  
OR MIL-S-5059 (ANNEALED) 2B FINISH  
16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs EACH

DESIGN	<i>b</i>	DART AEROSPACE LTD
DRAWN	<i>b</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PH</i>	DRAWING NO. REV. 8
MFG. APPR.	<i>PH</i>	D3589 SHEET 7 OF 8
APPROVED	<i>MP</i>	TITLE SCALE
DE APPR.	<i>MP</i>	LATCH ASSEMBLY KTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD. THE DOCUMENT IS PROPRIETARY INFORMATION AND IS PROVIDED UNDER THE TERMS OF A LICENSE AGREEMENT THAT PROHIBITS ITS USE FOR ANY PURPOSE OR DISSEMINATION OR COMMUNICATING TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8 7 6 5 4 3 2 1 1

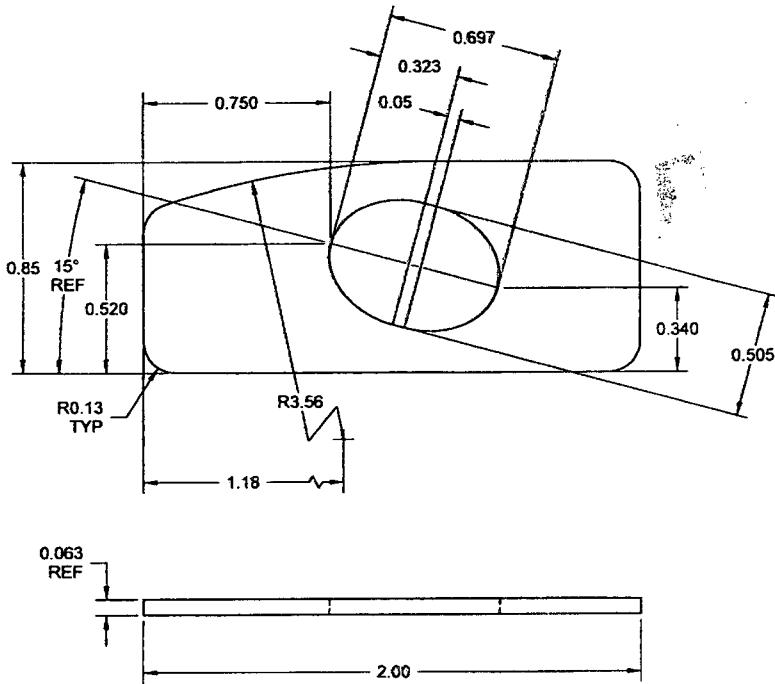
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

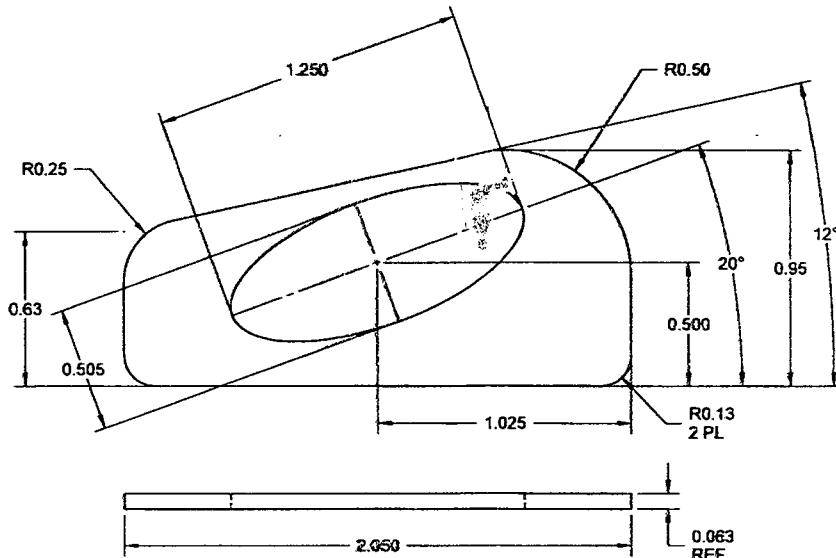
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

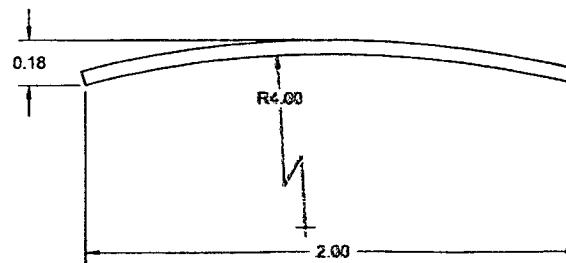
NOTE: Date & initial all entries



**D3589-17 FORWARD GUIDE PLATE**



**D3589-19F AFT GUIDE PLATE FLAT PATTERN**



**D3589-19 AFT GUIDE PLATE  
(MAKE FROM D3589-19F)**

**RELEASED**  
09/02/05/11

W10 55703

**D3589-17/-19/-19F NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524,  
OR MIL-S-5059 (ANNEALED) 2B FINISH  
16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs EACH

DESIGN	A	DART AEROSPACE LTD
DRAWN	B	HAWKESBURY, ONTARIO, CANADA
CHECKED	C	DRAWING NO. D3589
MFG. APPR.	D	REV. B
APPROVED	E	SHEET 8 OF 8
DE APPR.	F	TITLE LATCH ASSEMBLY
DATE	G	SCALE NTS
		08.06.25

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries